

Work Order ID 65535

Wednesday, January 19, 2011 1:14:41 PM



ASAP

Page 1

Item ID: D3955-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 1/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-01-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

6061 . 063

Memo

1-Cut as per Dwg D3955-1

Dwg Rev: AProg Rev: D

2-Deburr if necessary

11-1-20

B

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


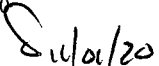

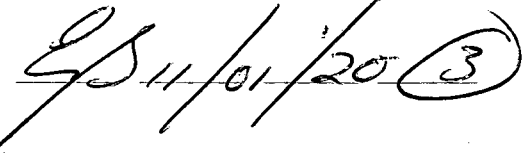

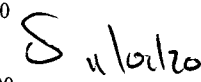
Work Order ID 65535

Wednesday, January 19, 2011 1:14:41 PM

Page 2

Item ID: D3955-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Doubler Assembly
Start Date: 1/19/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 1/25/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				 (3)			
130  Small Fab Small Fab	Memo 1- C'sink holes as per dwg 2- Deburr if necessary	0.00 0.00							 11/01/20 (3)
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				 (3)			

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries




Work Order ID 65535

Wednesday, January 19, 2011 1:14:41 PM

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Item ID:	D3955-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler Assembly					
Start Date:	1/19/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/25/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble nut plate as per dwg								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		Sub 124				(x3)	
Quality Control									
200 	Identify as per dwg & Stock Location <u>97</u>	0.00							
Packaging	Memo	0.00							
Packaging									

Handwritten signature 1/24 (3)

(x3)

Handwritten signature 1.1.24 sf 32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, January 19, 2011 1:14:41 PM

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Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler Assembly

Start Date: 1/19/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/25/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/24

mf
10-11-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 19, 2011 1:14:35 PM

Page 1

Work Order ID: 65535

Parent Item: D3955-041

Parent Item Name: Doubler Assembly

Start Date: 1/19/2011


Required Date: 1/25/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	215.6000	0.3553	0.748			
													
6061-T6 .063 Sheet													


Location	Loc Qty	Loc Code
----------	---------	----------

MAT	179.6	
116308	35.6	
116623	144	
MAT21	36	
113608	36	

MS21086L3		Purchased	No			180	Each	14.0000	1	2			
													
Nut Plate													

Location	Loc Qty	Loc Code
----------	---------	----------

ST304	14	
112219	14	

MS20427M3-3		Purchased	No			180	Each	1,364.000	2	4			
													
Rivet													

Location	Loc Qty	Loc Code
----------	---------	----------

ST318	1364	
115589	1364	

B11-1-20

3

113608

ES 11/01/24

3

ES 11/01/24

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

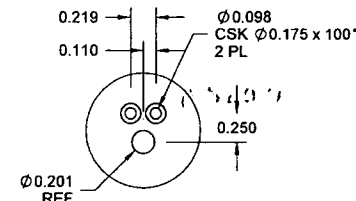
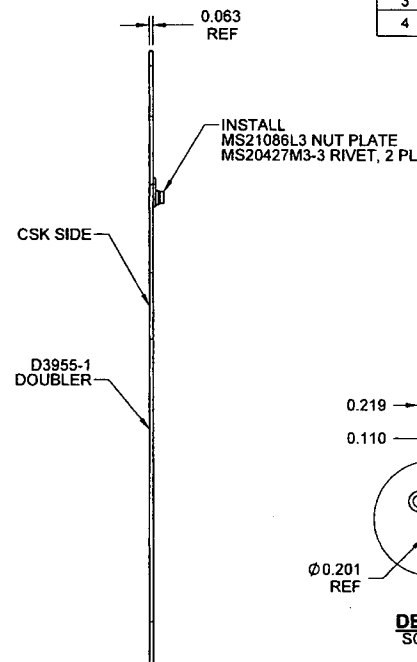
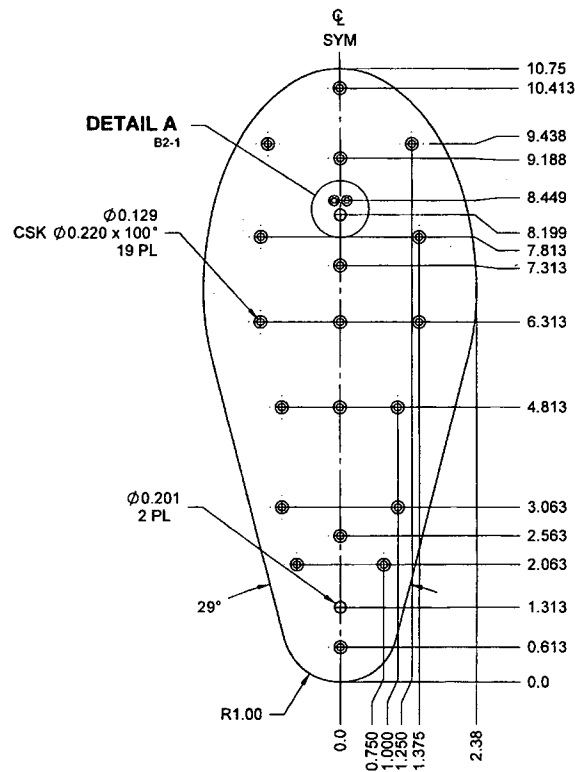
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
07/07/22

A NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION		BY DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE 09.07.21		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

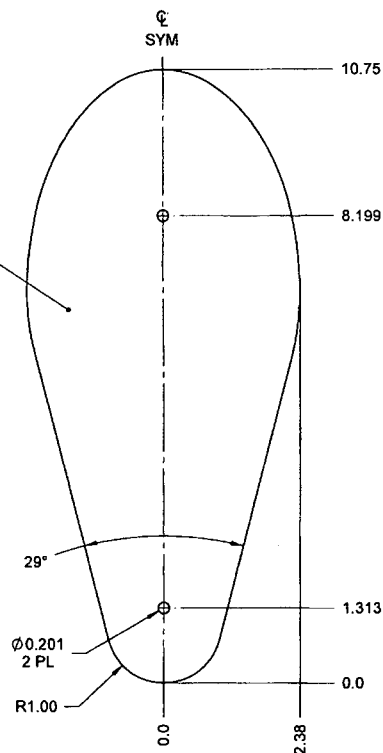
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

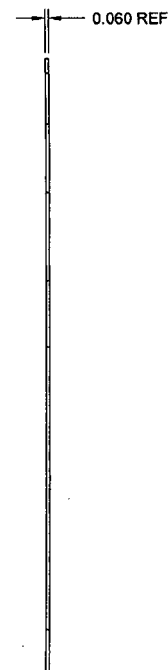
APPLY ANTI-SKID
ON ONE SIDE ONLY



D3955-3 COVER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs



#65535

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09/07/21

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
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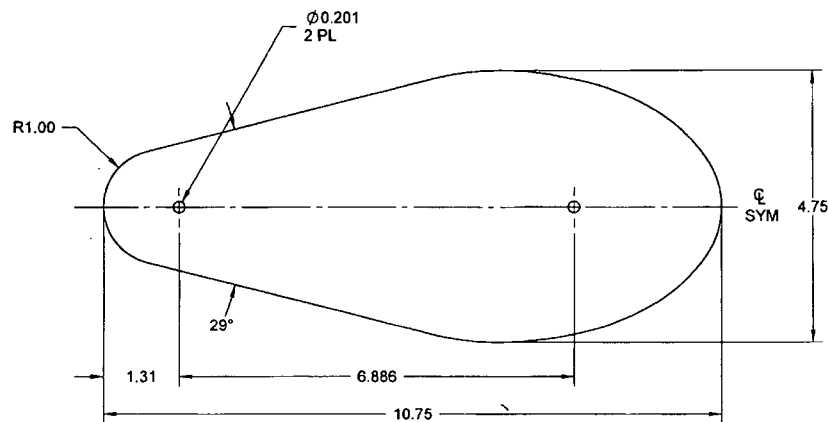
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304STGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

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09/07/21 MDD

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 3 OF 5
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W/O:		WORK ORDER CHANGES					
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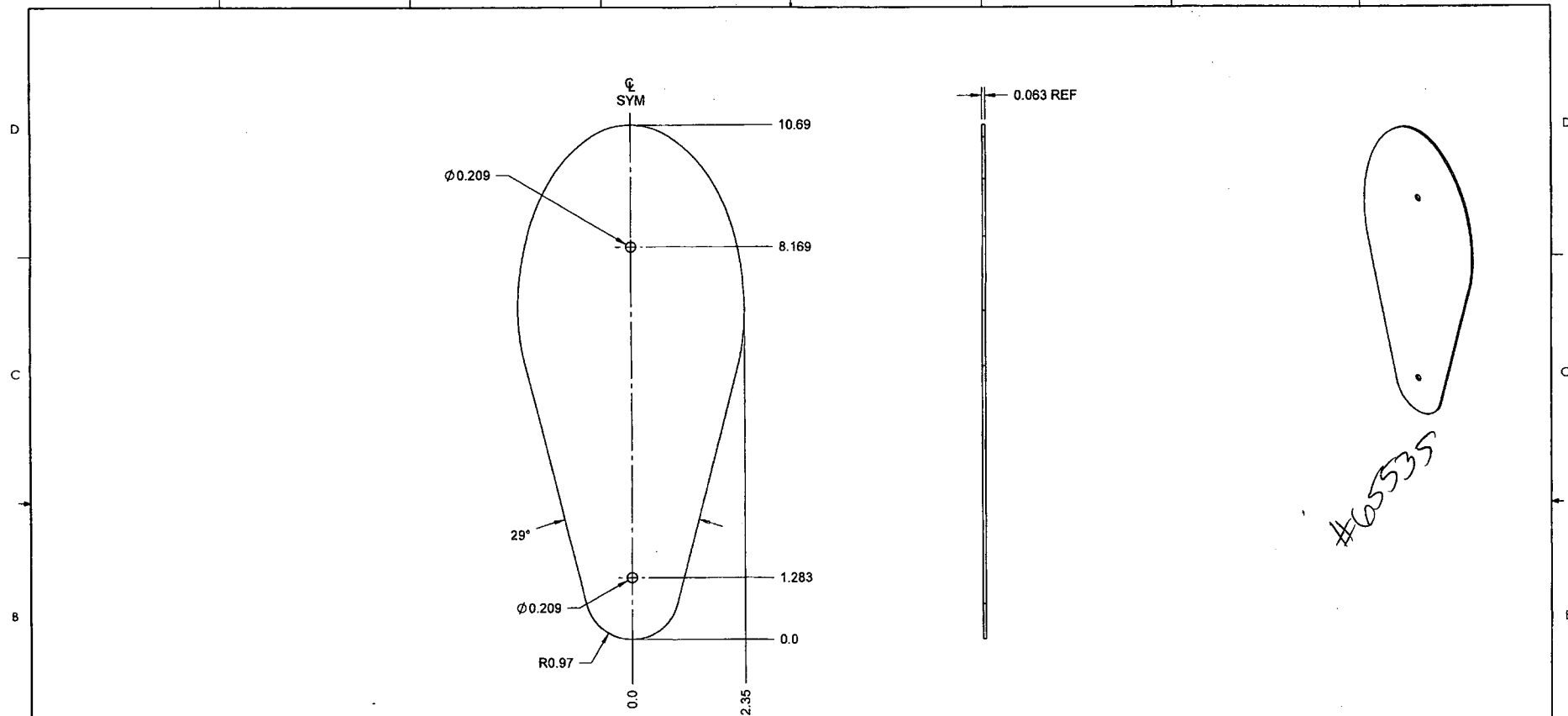
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

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21/07/22 MIB

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CHECKED		DRAWING NO. D3955	REV. A
MFG. APPR.		TITLE SKIDTUBE TUNING KIT	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

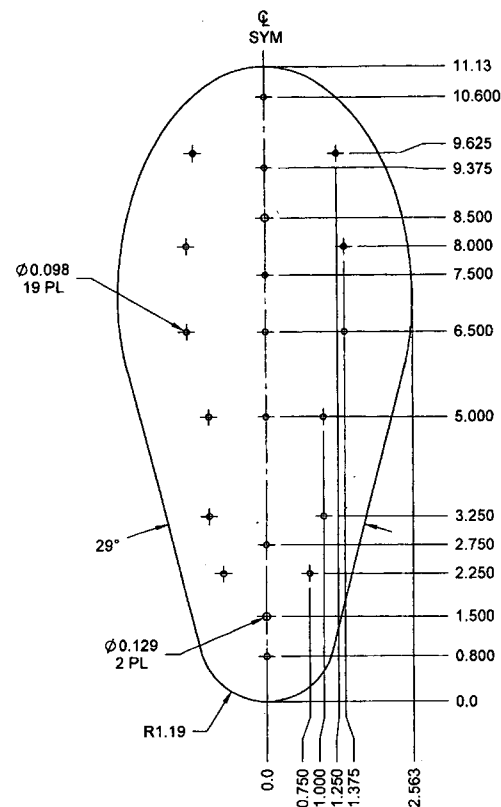
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

RELEASED
09/07/21

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. D3955	REV. A
MFG. APPR.			SHEET 5 OF 5
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DART AEROSPACE LTD		Work Order: 65535
Description: Doubler		Part Number: D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.133	X		V HB02	
Ø0.201	+0.005/-0.001	.205	X		V	
0.750	+/-0.010	.750	X		V	
1.000	+/-0.010	.998	X		V	
1.250	+/-0.010	1.247	X		V	
1.375	+/-0.010	1.371	X		V	
2.38	+/-0.030	2.376	X		V	
0.613	+/-0.010	.613	X		V	
1.313	+/-0.010	1.309	X		V	
2.063	+/-0.010	2.062	X		V	
2.563	+/-0.010	2.560	X		V	
3.063	+/-0.010	3.063	X		V	
4.813	+/-0.010	4.811	X		V	
6.313	+/-0.010	6.313	X		V	
7.313	+/-0.010	7.313	X		V	
7.813	+/-0.010	7.810	X		V	
8.199	+/-0.010	8.199	X		PROV HB02	PROV-JR
8.449	+/-0.010	8.449	X		PROV	"
9.188	+/-0.010	9.186	X		PROV	"
9.438	+/-0.010	9.437	X		PROV	"
10.413	+/-0.010	10.415	X		PROV	"
10.75	+/-0.030	10.755	X		PROV	"
0.063	+/-0.010	.060	X		V	

Measured by: KB
Date: 11-1-20

Audited by: S
Date: 11/01/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
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